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D2743**Job Sheet 191294****Part No:** D2743**Job Qty:** 120 pcs**Part Name:** Crossbolt Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/26/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Jason Leroux**Type:** Stock**Description:****Note:** DWG REV B IPP E 05.04.13 Reformat; removed tumble and deburr step KJ/JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	120 pcs	3/22/19	3/22/19	0.01	2.57	Hardinge - 1		W/03/14
110	QC 2	120 pcs	3/22/19	3/22/19	0.00	0.00	QC 2 - 1		"
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		

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				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
120	QC 8	120 pcs	3/22/19	0.00 0.00	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 47	
				QC 8 - 40	
130	Skidtubes - 2 - B4B	120 pcs	3/22/19	0.00 0.94	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
160	Packaging 3-1 - Stock - B4B	120 pcs	3/22/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
170	QC 21 - SA	120 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Hardinge) 1-TURN AS PER FOLIO FA202 & DWG D2743 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Skidtubes) 1- Clean crossbolt spacer with ultra bright aluminum cleaner 160 - (Identify as per dwg & Stock Location: <u>4601</u>) ***STOCK IN SKIDTUBE CELL*** 170 - (QC21- Final Inspection - Work Order Release)					

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Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6T0.625W.065	6061-T6 Round Tube .625 X.065W	32.0040 ft (.2667 ea)	100-Hardinge - 1	2108443 2152953	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.625W.065	32	82	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cross Bolt Spacer	3.085inches	+ 0.030 - 0.000	3.115 3.085	
2	Cross Bolt Spacer	0.625inches	± 0.010	0.635 0.615	
3	Cross Bolt Spacer	0.050inches	± 0.010	0.060 0.040	
4	Cross Bolt Spacer	45.000Degrees	± 0.000	45.000 45.000	
5	Cross Bolt Spacer	0.065inches	± 0.010	0.075 0.055	

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Container No: S162846



Part: D2743

Job No: 191294

Serial No/Batch: S162846

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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